

Work Order ID 65432

January 17, 2011 1:36:58 PM



Page 1

Item ID: D4079-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp Half, Attachment

Start Date: 1/17/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/24/11 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 1/17/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4079

B

100

0.00



Bandsaw

Jeaspa Bandsaw

Memo

Cut blank 2.750" long

0.00

OK 11/02/01

4

0

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA931

Folio rev: AA

Dwg Rev: B

0.00

OK 11/02/22

4

0

Deburr

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

11/02/22

4

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

11/02/22

(4)

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

4

0

11/02/22

Hand Finishing

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Item ID:	D4079-1	Accept		Setup	Start	
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Start Date:	1/17/11	Start Qty:	4.00		Cust Item ID:	
Required Date:	1/24/11	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 112588</i> Memo	0.00 <i>3:15.</i> 0.00 <i>3:20</i> <i>3:45.</i>				<i>4</i>		<i>BR 11-2-23</i>	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>4</i>	<i>all "lock"</i>
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>PAP 24</i> Memo <i>64700</i> <i>2 HAFI</i>	0.00 0.00						<i>PAP 24</i>	<i>(4)</i>

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Start Date: 1/17/11 Start Qty: 4.00



Cust Item ID:

Required Date: 1/24/11 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/24 JF

mf
11-02-24

Picklist Print

Page 1

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Work Order ID: 65432



Parent Item: D4079-1



Parent Item Name: Clamp Half, Attachment

Start Date: 1/17/11

Required Date: 1/24/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	37.3442	0.23	0.968421			



6061-T6 Bar 2.00 x 2.00

Location

Loc Qty

Loc Code

MAT09

37.3442

→ 113006

15.8307

113123

12.5135

13085

9

.968 *ml 11/02/01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries

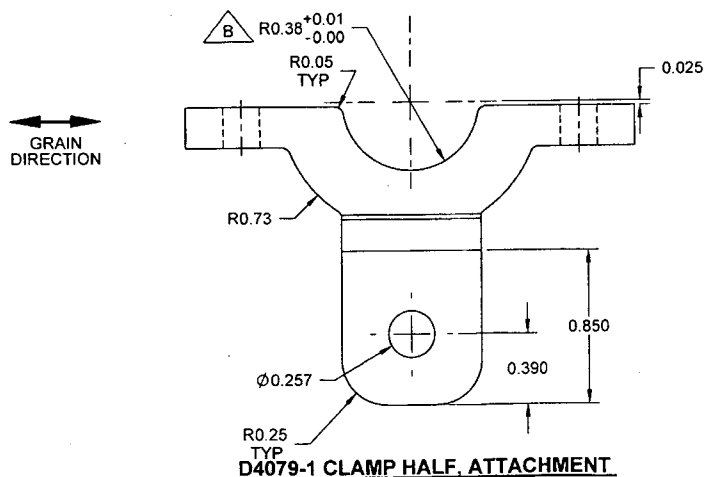
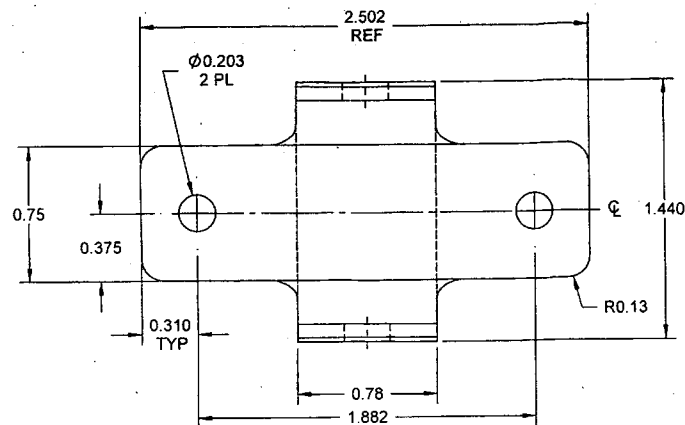
DART AEROSPACE LTD		Work Order:	65432
Description: Clamp Half, Attachment		Part Number:	D4079-1
Inspection Dwg: D4079	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.502	+/-0.010	2.503	✓		Vein	ML-7
Ø0.203	+0.005/-0.001	Ø.204	✓		"	"
0.75	+/-0.030	.745	✓		"	"
0.375	+/-0.010	.373	✓		"	"
0.310	+/-0.010	.309	✓		"	"
1.882	+/-0.010	1.880	✓		"	"
0.78	+/-0.030	.778	✓		"	"
R0.13	+/-0.030	R.130	✓		Rad-gage	REF
1.440	+/-0.010	1.439	✓		Vein	ML-7
R0.38	+0.010/-0.000	R.383	✓		"	"
R0.050	+/-0.010	R.050	✓		"	"
R0.73	+/-0.030	R.725	✓		"	"
Ø0.257	+0.006/-0.001	Ø.259	✓		"	"
R0.25	+/-0.030	R.250	✓		Rad-gage	REF
0.390	+/-0.010	.390	✓		Vein	ML-7
0.850	+/-0.010	.850	✓		"	"
0.025 x 45°	+/-0.010 x 0.5°	.030 x 45°	✓		"	"
0.100	+/-0.010	.099	✓		"	"
R0.05	+/-0.030	R.050	✓		"	"
1.240	+/-0.010	1.238	✓		"	"
1.65	+/-0.030	1.652	✓		"	"
0.60	+/-0.030	.602	✓		"	"
0.23	+/-0.030	.225	✓		"	"
0.025	+/-0.010	.025	✓		"	"

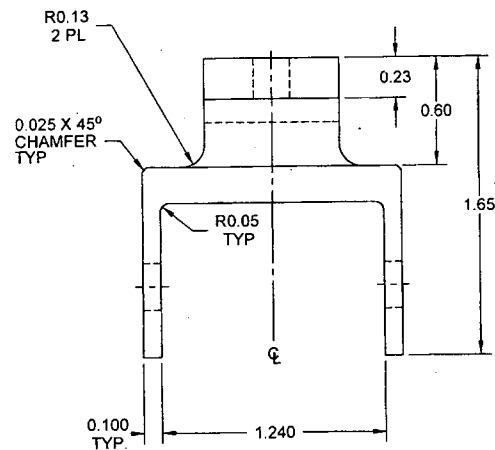
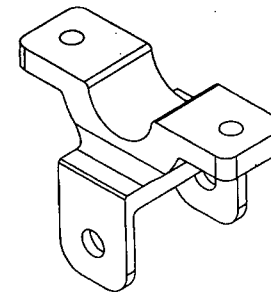
Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	11/02/22	Date:	11/02/22	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	<i>[Signature]</i>



D4079-1 CLAMP HALF ATTACHMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65432
CZ1110117



RELEASED
2010-09-07
MP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

B	R0.38 WAS R0.48.	JB	10.07.30
A	NEW ISSUE	JB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN		JB	
DRAWN		JB	
CHECKED		JB	
MFG. APPR.		JB	
APPROVED		JB	
DE APPR.		JB	
DATE	10.07.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4079	REV. B SHEET 1 OF 1
TITLE CLAMP HALF ATTACHMENT	SCALE NTS
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